

Data

Engines	Valve	Height "h" of valve retainer (Fig.) when new		Adjusting angle "α" for machining valve	Valve stem dia.	Valve seat plating	Filled-in sodium	Valve length
			limit value					

Intake valves

115.923/926 115.938/939	$\frac{44.30}{44.10}$	1.5	1.0	45° + 15'	$\frac{8.97}{8.95}$	with	without	128
115.951/954	$\frac{47.10}{46.90}$					without		

Exhaust valves

115.923/926 115.938/939	$\frac{37.20}{37.00}$	2.5	2.0	45° + 15'	$\frac{10.96}{10.94}$	with	with	113.2
115.951/954								

Width of valve seat	intake 1.8—3	exhaust 1.5—2.5
Permissible runout on valve stem and valve seat max.	0.03	

Conventional tools

Valve cone grinder or Valve cone machining tool	e.g. made by Krupp, D—5309 Meckenheim model VS e.g. made by Hunger, D—8000 München 70 type VKDR1, order No. 203.00.200
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Note

Exhaust valves are filled with sodium!

When scrapping valves, pay attention to safety rules.
Do not melt valves filled with sodium since there is
a risk of explosion and do not use such valves for
making tools (punch etc.), without first removing
filled-in sodium.

Be careful when removing sodium from valves, since sodium mixed with water and watery solutions reacts heavily explosive, while the resulting hydrogen gas may cause fires.

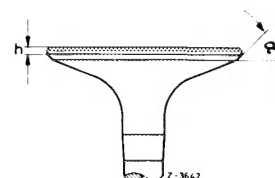
Sodium from cut-up or broken-up valves can be neutralized in the mixture comprising 2 liters spirit of alcohol and 1 liter of water put into a vessel and placed in the open air.

Valves filled with sodium can be collected and shipped for neutralizing to: Garantieprüfstelle Werk Stuttgart-Untertürkheim.

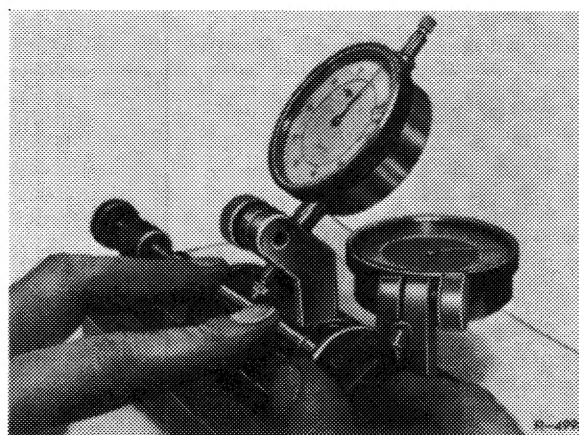
Checking and machining

- 1 Clean valves and check visually.

Valves with a burnt valve retainer, with insufficient height "h" of valve retainer and valves with worn-out or scored valve stem should be replaced.



- 2 Measure runout on valve stem. If runout exceeds 0.03 mm, replace valve.



- 3 Machine valve seat.

Refer to operating instructions of machining tool and make sure of 45° adjusting angle.

- 4 Measure runout on valve seat and height "h" of valve retainer.

When the limit values are attained, replace valve.

